

731-011

Dart Aerospace Ltd.

Date: Wednesday, 22/04/2009 11:38:28 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: MECHANICAL GROUND HANDLING WHEEL KIT
<b>Job Number</b>	: 47362A		
<b>Estimate Number</b>	: 12136		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D206731041
<b>This Issue</b>	: 22/04/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: DSK 093 REV B
<b>First Issue</b>	: //	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 45681A	<b>Drawing Revision</b>	: B
	<b>Type</b> : MACHINED PARTS	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 05/06/2009
<b>Checked &amp; Approved By</b>	: <u>2009.04.22</u>	<b>Qty:</b>	1 Um: Each
<b>Comment</b>	: est rev. A 01.02.01 new issue EC Est Rev:B As per Rev B 07-02-13 JLM est rev C 07.05.14 rev C IIN Ec		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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✓ - 1.0	D33355	spring
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3335-5	spring	<u>B47614</u>

SAD 09-05-13

✓ 2.0	D3353041	Lug Weldment
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

LUG ARM WELDMENT

Batch: B47615

SM 09-05-13

✓ 3.0	D3354041	Left Arm Weldment
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3354-041	Left Arm Weldment	<u>B42476</u>

SM 09-05-13

✓ 4.0	D3354043	Right Arm Weldment
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

RIGHT ARM WELDMENT

batch: B36639

SM 09-05-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: MECHANICAL GROUND HANDLING WHEEL KIT

Job Number: 47362A

Part Number: D206731041

Job Number:



Seq. #: Machine Or Operation: Description :

✓ 5.0 D33561 Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3356-1	pin	<del>B36640</del> B36640

SAD 09-05-13

✓ 6.0 D3397041 Wheel Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	D3397-041	Wheel ass'y	B36529-2

SAD 09-05-13

✓ 7.0 113800 GREASE FITTING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	113-800	GREASE FITTING	M109654

SAD 09-05-13

✓ 8.0 656051 flat washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	656-051	flat washer	105735

SAD 09-05-13

✓ 9.0 663079 Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	663-079	Lock washer	16362

SAD 09-05-13

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 47362A

Part Number: D206731041

Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ 10.0 AN523A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	AN5-23A	Bolt	<u>M19278</u>

SAD 09-05-13

✓ 11.0 AN960JD516 Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	AN960JD516	Washer	<u>M110523</u>

SAD 09-05-13

✓ 12.0 CP21 1/8" Cotter Pin 2" long



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	CP21	1/8" Cotter Pin 2" long	<u>M108200</u>

SAD 09-05-13

✓ 13.0 MS21042L5 Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	MS21042L5	Nut	<u>M109840</u>

SAD 09-05-13

✓ 14.0 SNF34 SLOTTED NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	SNF-34	SLOTTED NUT	<del>M108345 (1)</del>

~~M11044 (1)~~

M111550 (2)

SAD 09-05-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 47362A

Part Number: D206731041

Job Number:



Seq. #: Machine Or Operation: Description :

✓ 15.0 TP2 Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	TP-2	Spring pin	m16588

SAD 09-05-13

✓ 16.0 TP134 Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

qty	Part Number	Description	batch
1	TP-134	Spring pin	m16362

SAD 09-05-13

17.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble as per dwg DSK 093

2-Grease fitting 113-800, apply LPS C30316 on all parts areas not protected by paint or grease. SAD 09-05-13

18.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/05/15 (21)

19.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

POP 47362

SS 09/05/15 (21)

20.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/19 (21)

Job Completion



MF 09-05-15

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

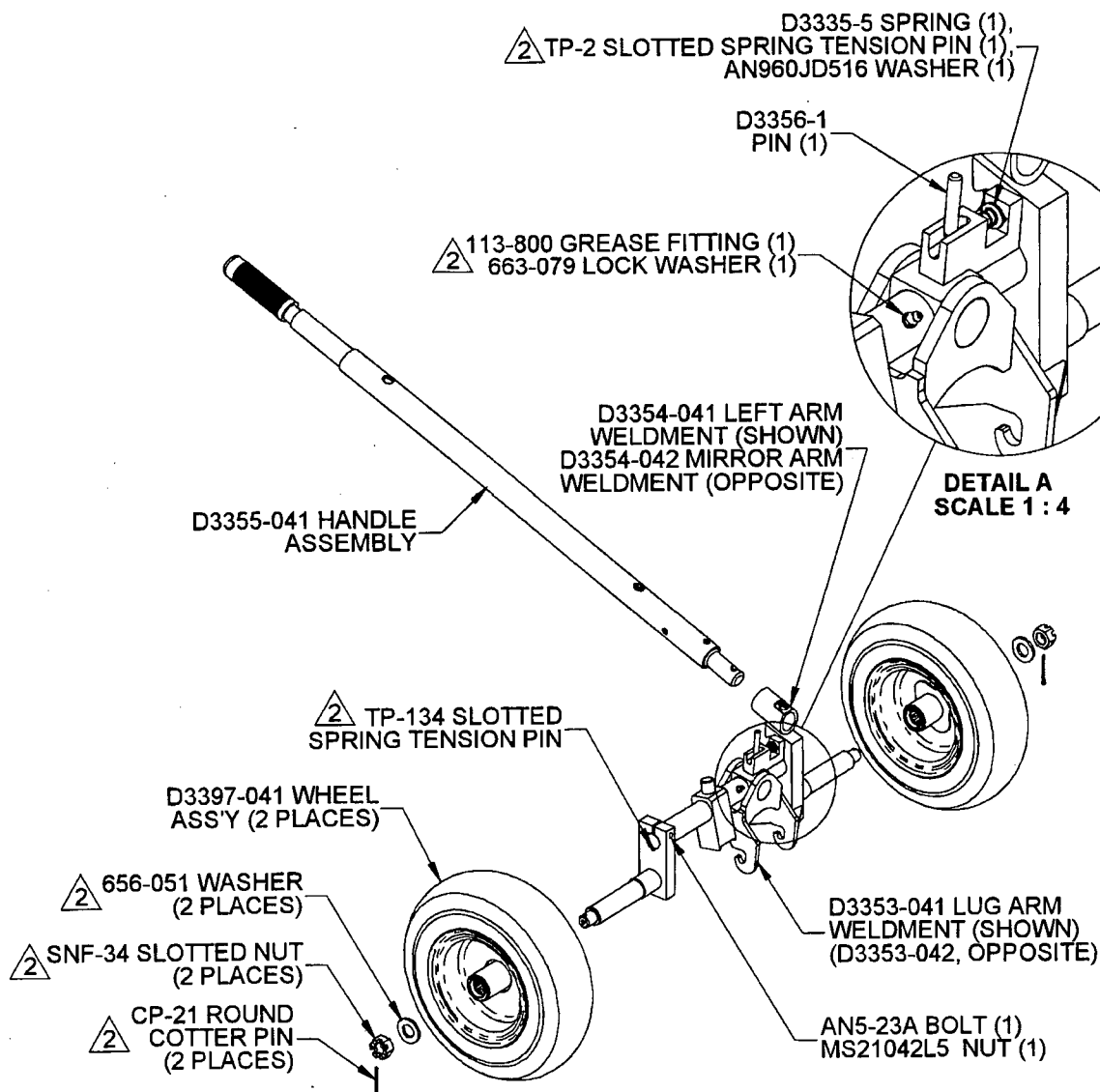
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**NOTE:** Date & initial all entries



**DART****RELEASED**  
07.02.02

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>DSK 093</b>	REV. B SHEET 1 OF 1
DATE <b>07.02.02</b>		TITLE <b>MECH. GROUND HANDLING</b>	SCALE 1:10
REV	DATE	DESCRIPTION	
A	05.02.10	NEW ISSUE	
B	07.02.02	REDRAWN	



**D206-731-041, LH MECHANICAL GROUND HANDLING (SHOWN)**  
**D206-731-042, RH MECHANICAL GROUND HANDLING (OPPOSITE)**

**NOTE:**

- 1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE.  
RUST INHIBITOR POSSIBLE SUPPLIER: ACKLANDS-GRANGER INC., P/N LPSC30316.
- 2) SUPPLIER: SPAENAUR.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **47362A**

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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